

Work Order ID 76047

Thursday, November 03, 2011 12:37:52 PM

76047

Page 1

Item ID: D4095-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/4/2011 Start Qty: 6.00

Required Date: 11/9/2011 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 11/11/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATERJET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-1)

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

110

QC2- Inspect parts off machine F/AI/F/AIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B11-11-14

(6)

B11-11-14

A 11 - 11 - 11 6

Work Order ID 76047

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76047

Page 2

Item ID: D4095-041

Revision ID:

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Start Date: 11/4/2011 Start Qty: 6.00

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

1- bend section C-C first

2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155

3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

SB 11/10/11

140

140

QC

Quality Control

QC3- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D4095

150

150

Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: M119373

Large Fab

0.00

Memo

0.00

X2 JBL 11-11-15

Work Order ID 76047

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Page 4

Item ID: D4095-041
 Revision ID:
 Item Name: Wearplate Assembly
 Start Date: 11/4/2011 Start Qty: 6.00
 Required Date: 11/9/2011 Req'd Qty: 6.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan:
 QC:

Date:
 Date:

Tooling:
 SPC (Y/N):

Date:
 Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

2

BR 11-11-17.

200

Identify as per dwg & Stock Location: **FP-1**

0.00

200

Packaging

Memo

0.00

Packaging

2

BR 11-11-17.

210

QC21- Final Inspection - Work Order Release

0.00


210

QC

Memo

0.00

Quality Control

11/11/21 

11/11/18

Picklist Print

Thursday, November 03, 2011 12:37:51 P

Page 1

Work Order ID: 76047

Parent Item: D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 11/4/2011

Required Date: 11/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	164.9000	2.275	14.368421			

Location

MAT020

119346

Loc Qty

164.9

164.9

Loc Code

119346

11-11-11

DART AEROSPACE LTD

Work Order: 76047

Description: WINGPLATE ASSEMBLY

Part Number: D4095-041

Inspection Dwg: D4095-1 Rev: ~~D4095-1~~ B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



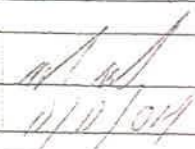
First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 19	4.005 - .031	19.0			V	1802
300	± .010	301			V	
303	± .010	303			V	
2432	± .010	2439			V	
3.227	± .010	3.222			V	
4.06	± .010	4.058			V	
4.98	± .010	4.986			V	
8.43	± .010	8.420			P	PROW502
9.72	± .010	9.710			P	
3.500	± .010	3.500			V	
24.75	± .010	24.756			T	1802
11.50	± .010	11.50			T	
11.472	± .010	11.472			T	
6.000	± .010	6.000			T	
12.104	± .010	12.104			T	
18.000	± .010	18.000			T	
32.000	± .010	32.000			T	
9.00	± .010	9.00			T	
36.000	± .010	36.006			T	
39.57	± .010	39.57			T	
2.50	± .010	2.501			V	
.063	± .010	.061			V	

Measured by: RB

Audited by: 

Prototype Approval:

Date: 11-11-4

Date: 11/10/04

Date:

Rev

Date

Change

Revised by

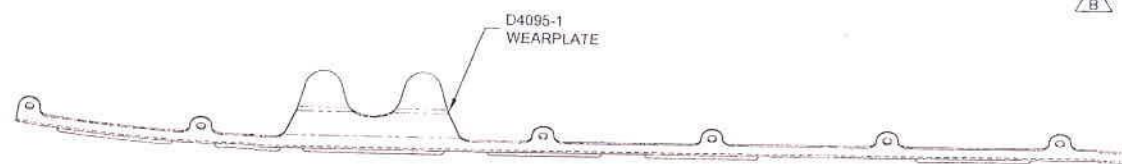
Approved

A

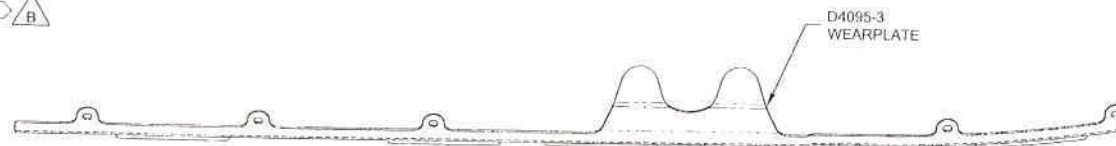
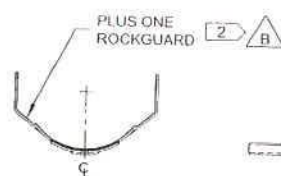
New Issue

KJULM

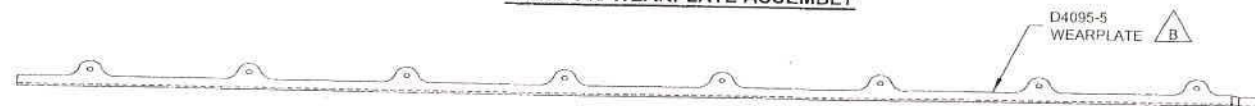
ITEM	QTY	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X							D4095-041	WEARPLATE ASSEMBLY
2		X						D4095-043	WEARPLATE ASSEMBLY
3			X					D4095-045	WEARPLATE ASSEMBLY
4				X				D4095-047	WEARPAD ASSEMBLY
5					X			D4095-049	WEARPAD ASSEMBLY
6						X		D4095-051	WEARPAD ASSEMBLY
7	1							D4095-1	WEARPLATE
8		1						D4095-3	WEARPLATE
9			1					D4095-5	WEARPLATE
10				1				D4095-7	WEARPAD
11					1			D4095-9	WEARPAD
12						1		D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAH)



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



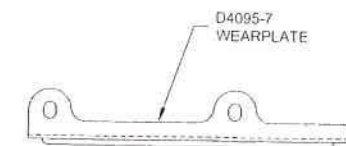
D4095-045 WEARPLATE ASSEMBLY

D4095-041/-043/-045/-047/-049/-051 NOTES:

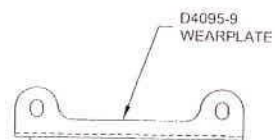
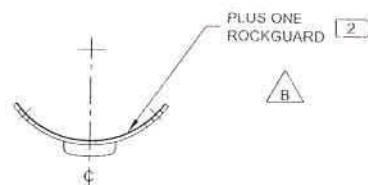
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-DXX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B		REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN. REVISED NOTE 2		XDF	11.10.18
A		NEW ISSUE		MB	10.04.20
REV.	DESCRIPTION			BY	DATE
DESIGN	J			DART AEROSPACE USA, INC	
DRAWN	XDF			KENT, WA	
CHECKED	AP			DRAWING NO.	REV. B
MFG. APPR.	AP			D4095	SHEET 1 OF 8
APPROVED	AP			TITLE	SCALE
DE APPR.	H			WEARPLATE	NTS
DATE	11.10.18			COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	

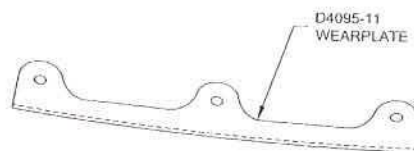
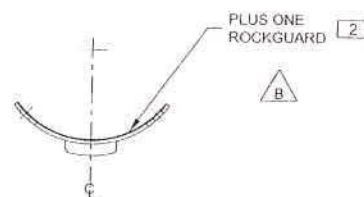
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2011-10-31



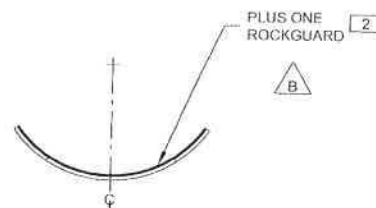
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY

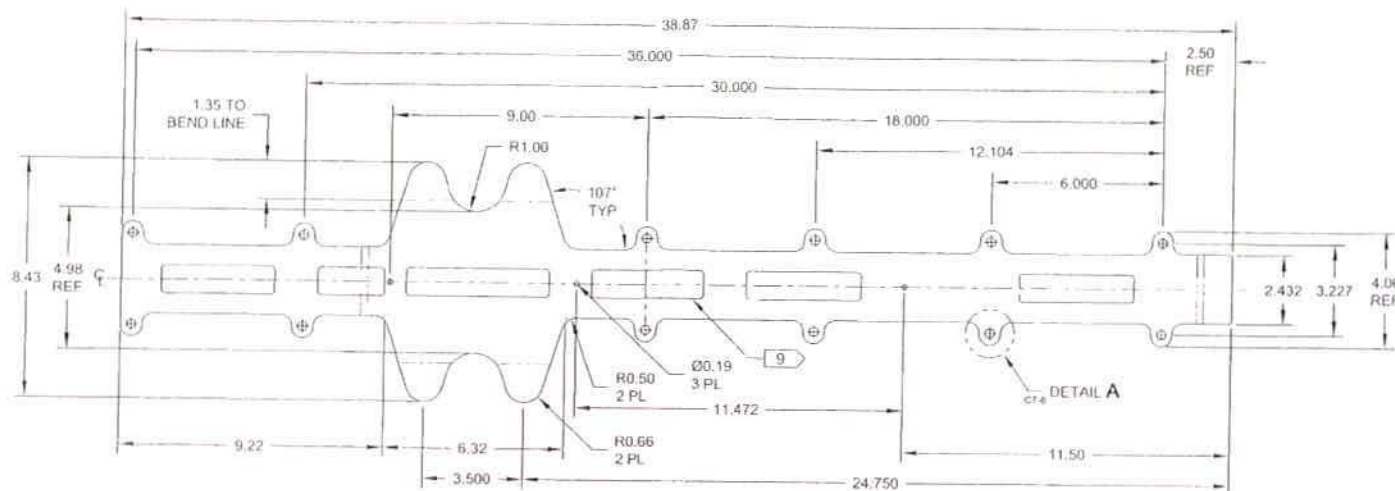


D4095-051 WEARPAD ASSEMBLY

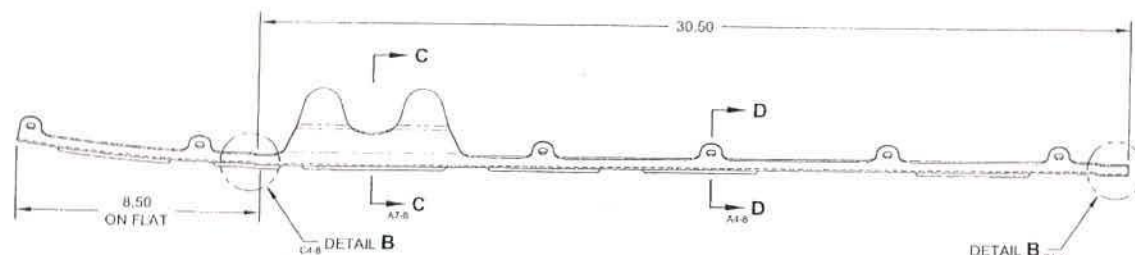


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2011-10-3
JWP

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D4095-1F FLAT PATTERN

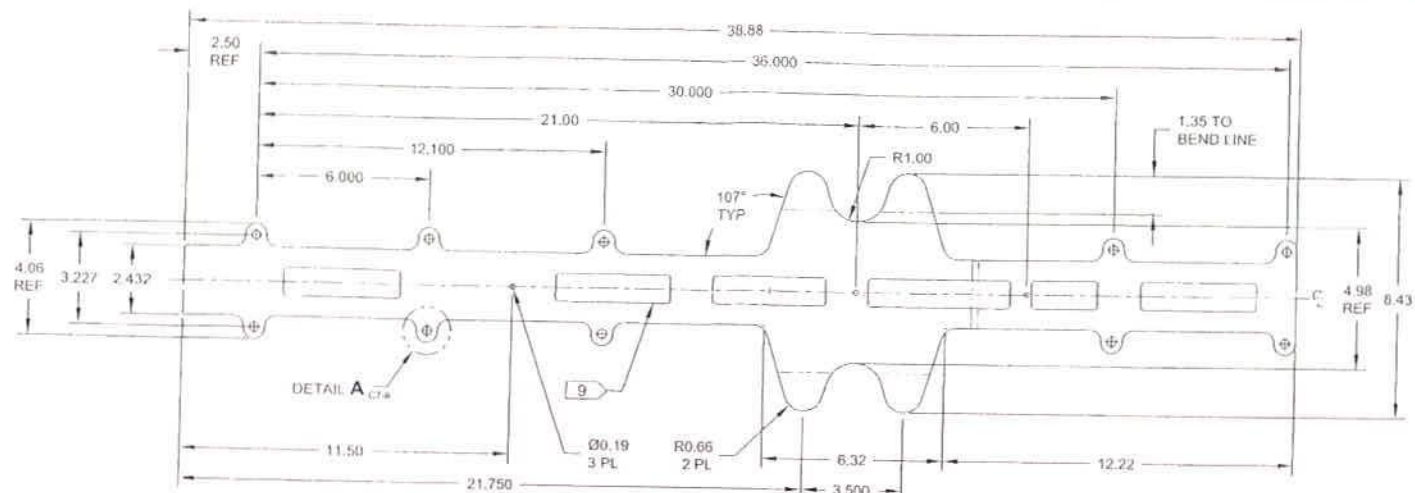


D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

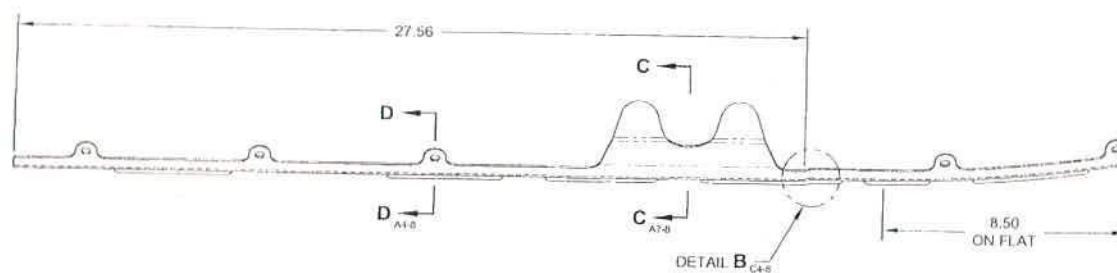
D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

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MFG. APPR.	10	D4095	SHEET 3 OF 8
APPROVED	10	TITLE	SCALE
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D4095-3F FLAT PATTERN

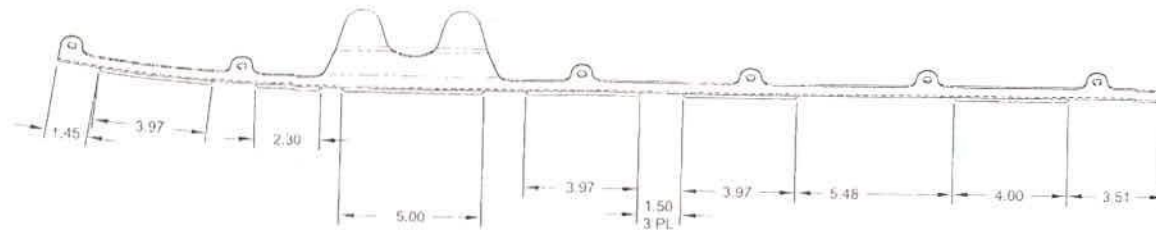


D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

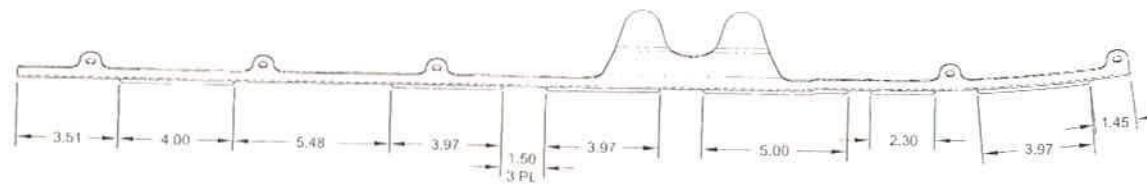
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DRAWN	XDF	KENT, WA
CHECKED	10	DRAWING NO. REV. B
MFG. APPR.	10	D4095 SHEET 4 OF 8
APPROVED	10	TITLE SCALE
DE APPR.	10	WEARPLATE NTS
DATE	11.10.18	

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2011-10-31



D4095-1 WELDING DETAIL

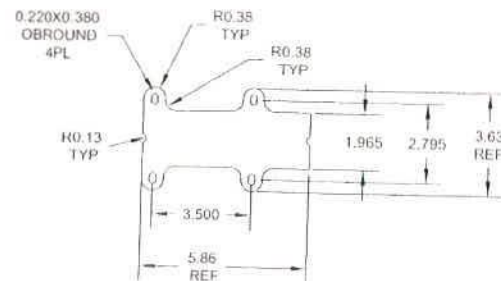


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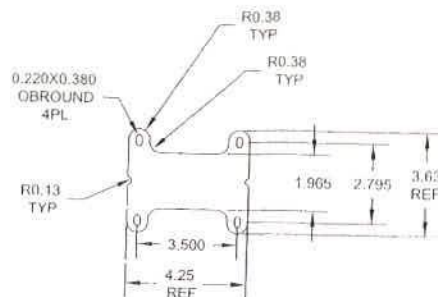


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2011-10-31
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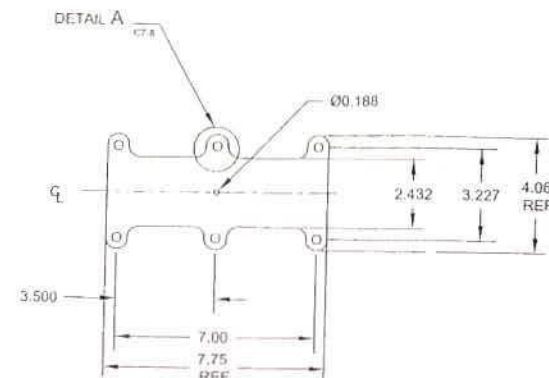
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DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 5 OF 8
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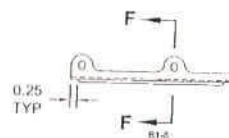
D4095-7F FLAT PATTERN



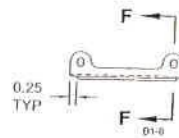
D4095-9F FLAT PATTERN



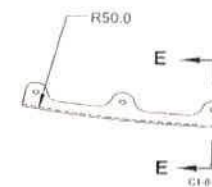
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)

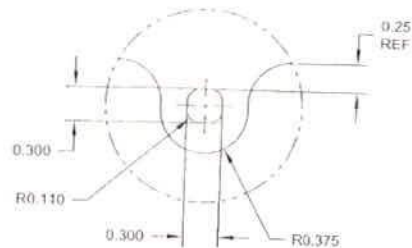


D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



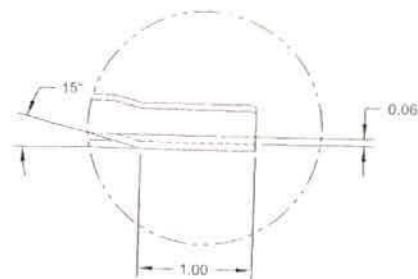
D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 7 OF 8
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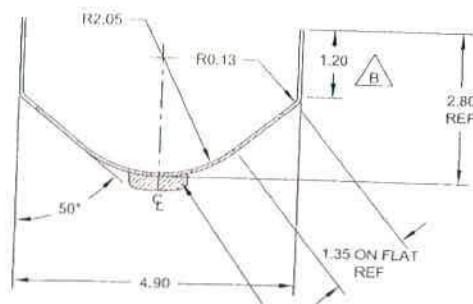
DETAIL A: TAB DETAIL

SCALE 4X
C-1
C-2
D-1
D-2



DETAIL B: JOGGLE DETAIL

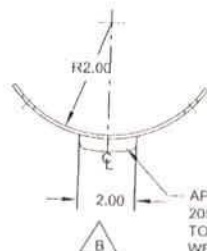
SCALE 4X
B-1
B-2
B-3
B-4



SECTION C-C

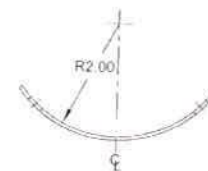
SCALE 2X
B-1
B-2

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



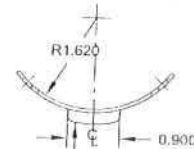
SECTION D-D

SCALE 2X
B-1
B-2



SECTION E-E

SCALE 2X
B-1
B-2



SECTION F-F

SCALE 2X
B-1
B-2

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DRAWN	XDF	KENT, WA	
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MFG. APPR.		D4095	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	

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2011-10-3